Work Order II October-19-11 1:28:2			*752	240*						Page 1
	04-1 sbolt Spacer 0/2011		Accept	*N900		100)* s	Setup Star Stop	IVI	S1* S2*
Required Date: 07/1	1/2011 Req'd Qty: 20.00			Customer:						
Reference: Approvals: Pro	cess Plan: MLJ	Date: \\\0\\9	Taoling		ate:	·-	F	Run Star	t *N	R1*
QC	• •	Date:	SPC (Y/N):		ate:			Stop		R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3504	Rev C									$\mathcal{A}_{\mathcal{E}}$
100			0.00					•		
100	Hardinge CNC LATHE	E SMALL					20	0		Sf. 11/10/-
Hardinge	Memo		0.00							
Hardinge CNC Lathe Smal	FOLIO RE DWG RE		G D3504 ,						<u>.</u>	· · ·
110	QC2- Inspect parts off	machine FAI/FAIB	0.00							
110 QC	Мето		0.00				20	U		12 uliola
Quality Control										
120	QC8- Inspect parts - se	econd check	0.00							
120				150011	(0.5	27	20	4		
QC	Memo		0.00							
Quality Control										

Dart Aeros	pace Ltd
------------	----------

W/O:			WO	RK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									E 1 -
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DC	QA:	_ Date: _	
	Re	esolution:	Disposition	:	QA: N/C (Closed: _		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	IANCE (NC	R)	-		
DATE	STEP	Description of NC	Description of NC Corrective Action			verit			Approval
	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng	Dat		tion C	Chief Eng	QC Inspector

Work Ord		240		*752	240*					Page 2
Item ID: Revision ID: Item Name:	D3504-1 Crossbolt Spa	ncer		Accept	*N900	<u>040</u>	100)* s	Setup Star	1/2/1
Start Date: Required Date: Reference:	19/10/2011 : 07/11/2011	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:				14.57
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:	dige	R	Run Sta	" *NR1*
	QC:		Date:	SPC (Y/N):	D:	ate:			Sto	*NR2*
Sequence ID/ Work Center I	D	Operation Description	16	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
*130 *130* Packaging Packaging		Identify as per dwg & Sto Memo ***STOCK	in SKIDTUBE CELL***	0.00				20	0	BEN/19/29
		·	IN SKID FODE CELL							
140 * 140 *		QC21- Final Inspection -	Work Order Release	0.00						11 - las A
QC QC		Memo		0.00						N 10 121 P

Memo

Quality Control

M 10 31 -31

Dart	Aeros	pace	Ltd
------	--------------	------	-----

W/O:			WO	RK ORDER CHANGE	S	.,		
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA :	Date: _	
Resolution:								
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)	· - · · · · · · · · · · · · · · · · · ·	
DATE	STEP	Description of NC		n B	Verificatio	n Approval	Approval	
	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
-								
		-						

Picklist Print

October-19-11 1:28:31 PM

Work Order ID: 75240

75240

Parent Item:

D3504-1

D3504-1

Parent Item Name: Crossbolt Spacer

Start Date: 19/10/2011

Required Date: 07/11/2011

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A New Issue 06-06-20 JLM

IPP Rev:B Rev C dwg 07-12-06 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Statu
M6061T6T0.500W.049		Purchased	No			100	f	284.8565	0.283	5.957895		11	
M6061T6	STO 500'	W 049	•						**	5.983	, t	11	11/10/2

6061-T6 RD Tube .500 x.049W

Location Loc Oty Loc Code 284.856481 MAT014 5.983' 117270 284.856481

Dart Aerospa	ce Ltd
--------------	--------

W/O:			WC	RK ORDER CHANG	GES		***		
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								, 100 mg.	
									·
	<u> </u>								
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA:		_ Date: _	
	Re	solution:	Disposition	n:	QA: N/C Ck	osed:		Date:	
NCR:			WORK ORD	R NON-CONFORM	ANCE (NCR)			
	T	Description of NC Corrective Action			ction B	Verifica	tion	Approval	Approval
DATE	STEP	Section A	initial Chief Eng	Action Description Chief Eng	Sign & Date	& Section C		Chief Eng	QC Inspector
									ļ
									-
					,				!
					ļ		- 1		
		77.00.40							
I									

DART AEROSPACE LTD	Work Order:	75240
Description: Cross Bolt Spacer	Part Number:	D3504-1
Inspection Dwg: D3504 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prot	otype
---	---------------	------	-------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	\$ 0.500	1		5208	
0.049	+/-0.010	0.049			r	
3.475	+0.030/-0.000	3.490	/		61.	
Ø0.402	+0.006/-0.001	3.490			n	
······································						
· · · · · · · · · · · · · · · · · · ·						
						9-7-1

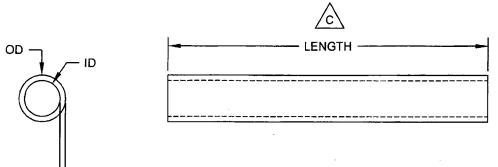
		·				
	1					

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11/10/2/	Date: 1/. 16.23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.03	New Issue	KJ/JLM	
В	06.12.14	3.480 revised to 3.475	KJ/JLM LA	
С	08.01.16	Dwg Rev updated	KJ/EC/DD	78

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / - Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _		
	R	esolution:	Disposition	QA: N/C C	QA: N/C Closed: Date:					
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	scription Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector	
			Orner Ling	Cilie Eng	Date					
								:		
								!		
1	1		1 1		i			1	1	



D3504-1/-3/-5 CROSS BOLT SPACER PARTS LIST

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15240 HCJ

/ U \	

PART NUMBER	OD	WALL	+0.030 -0.000	ID	MATERIAL SPEC	NOTE
D3504-1	0.500	0.049	3.475	0.402 (REF)	M6061T6T0.500W.049	SEE NOTE 1a)
D3504-3	0.375	0.049	3.475	0.277 (REF)	M6061T6T0.375W.049	SEE NOTE 1a)
D3504-5	0.750	0.080 (REF)	3.400	0.590	M6061T6R0.750	SEE NOTE 1b)

07.09.19

D3504-1/-3/-5 CROSS BOLT SPACER:

1) MATERIAL: a) 6061-T6 OR 6061-T62 TUBING

PER WW-T-700/6 OR AMS 4080 OR AMS 4082

OR QQ-A-200/8 OR QQ-A-225/8

- WALL

(REF. DART SPEC, M6061T6TD.DDDW.TTT)

b) 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR

PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R0.750)

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



DESIGN	PH	DART AER	ROSPACE	
REV.		BY	DATE	
Α	NEW ISSUE	PH	06.04.21	
В	3.475 WAS 3.400	PH	06.11.01	
С	ADD -5	DC	07.09.19	

DESIGN	PH	J DAKT AEROSPA	ICE LID			
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA				
CHECKED	PH	DRAWING NO.	REV. C			
MFG. APPR.	12-0	D3504	SHEET 1 OF 1			
APPROVED	M	TITLE	SCALE			
DE APPR.		CROSS BOLT SPACER	NTS			
DATE OZO	0.40	COPYRIGHT © 2006 BY DART AER				

Dart Aerospace Ltd

	•								
W/O:			WC	RK ORDER CHANG	ES		_		
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								,	
		•							
								e.	
								۶.	
Part No		PAR #:	Fault Cate	gory:	_ NCR: Ye	s No DC)A:	Date: _	
			Disposition: C						
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NO	R)			
DATE	STEP	Description of NC ———————————————————————————————————			Section B N Sign & Section C				Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Da Da		tion C	Chief Eng	QC Inspector
								1	
				.					